

Work Order ID 58785

Wednesday, May 19, 2010 9:15:32 AM



Page 1

Item ID: D350-591-117A

Accept



Setup Start



Revision ID:

Item Name: Pre-Flight Step

Stop



Start Date: 5/18/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/25/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-5-19

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
N/A	Rev G

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-591-117A CHG002

0.00

0.00

Sub 21

10-6-21 CL 10/06/21

3 mfr. 10-6-21.

Pto ->

per ecn 10-586

110



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

10-6-21 (2x) sf

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

Sub 21

(x2)

W/O: 58785		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/6/21	# 100	Perm. Iron Missing Parts to DS79525. ADD missing part for new chose. D3595-200-300 B*41360 x Qty 1 Per kit <i>Sololed 21</i>	<i>[Signature]</i>	10-6-21			<i>[Signature]</i> 10/6/21
10/6/21		update w/b + Bom to new chng + ADD copy of Bom for Ref.	<i>[Signature]</i>	10.06.23			<i>[Signature]</i> 10/6/21

Part No: D350-591-117A PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58785

Wednesday, May 19, 2010 9:15:32 AM



Page 2

Item ID: D350-591-117A

Accept



Setup Start



Revision ID:

Stop



Item Name: Pre-Flight Step

Start Date: 5/18/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/25/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591

117A □ Location: _____ □ PPP Rev: D6/10/22 (2)

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/06/2310-6-22 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 19, 2010 9:15:37 AM

Page 1

Work Order ID: 58785

Parent Item: D350-591-117A

Parent Item Name: Pre-Flight Step

Comments: IPP Rev:A New Issue 06-06-28 JLM
IPP Rev:B 08-09-09 under review as per PAR 08-031 DD
IPP Rev C 09.02.06 ECN 09-513 EC verified by:DD

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ AN4-22A	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 120	Unit of Each	Qty on 228.0000	Qty per Kit 4	Qty	Date	Status
											10.6.215	

Location	Loc Qty	Loc Code
ST359	228	
111965	128	
114523	100	

S 12 AN960JD416	Purchased	No				120	Each	0.0000	4			
Washer												
D2171	Manufactured	No				120	Each	96.0000	2			
Clamp												

Location	Loc Qty	Loc Code
ST456	96	
41535	96	
	f	

D2182B	Manufactured	No				120	f	328.4138	0.58			
Rubber Cushion												

Location	Loc Qty	Loc Code
ST402A	9.67	
30872	9.67	
ST410	318.7438	
52649	318.7438	

to →

W/O: 58785		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		D3595-200-300 B 41360 (1x)	SP	10-6-21			

Part No: D350-591-117A PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Wednesday, May 19, 2010 9:15:37 AM

Work Order ID: 58785

Parent Item: D350-591-117A

Parent Item Name: Pre-Flight Step

Comments: IPP Rev:A New Issue 06-06-28 JLM
 IPP Rev:B 08-09-09 under review as per PAR 08-031 DD
 IPP Rev C 09.02.06 ECN 09-513 EC verified by:DD

Start Date: 5/18/2010

Required Date: 5/25/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
D2274		Manufactured	No			120	Each	569.0000	4			

Radius Block

Location	Loc Qty	Loc Code
ST010	569	
54850	4	
56686	59	
57714	233	
57912	273	

D2362-041	Manufactured	No			120	Each	0.0000	1			
-----------	--------------	----	--	--	-----	------	--------	---	--	--	--

350 Pre-Flite Step

D2856-400	Manufactured	No			120	f	280.7288	0.6			
-----------	--------------	----	--	--	-----	---	----------	-----	--	--	--

Abraison Strip

7.20 x 7.20 in measurer
 Sold (b)

Location	Loc Qty	Loc Code
ST403	280.7288	
50593	73.6768	
56626	207.052	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, May 19, 2010 9:15:37 AM

Work Order ID: 58785



Parent Item: D350-591-117A



Parent Item Name: Pre-Flight Step

Start Date: 5/18/2010

Required Date: 5/25/2010

Comments: IPP Rev:A New Issue 06-06-28 JLM
 IPP Rev:B 08-09-09 under review as per PAR 08-031 DD
 IPP Rev C 09.02.06 ECN 09-513 EC verified by:DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Qty	Date	Status
MS21042L4		Purchased	No			120	Each	2,797.000	4.			



Nut



10.6.21 SP (20)

Location	Loc Qty	Loc Code
ST139	2	
111827	2	
ST300	2795	
113422	80	
114523	1707	
114718	1000	
9063	8	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	Heli-Access-Step ™, Long Step – High Skid
	X					D350-591-113	Heli-Access-Step ™, Short Step – High Skid
		X				D350-591-115	Heli-Access-Step ™, Short Step – Low Skid
			X			D350-591-117A	Heli-Access-Step ™, Pre-Flight Step
				X		D350-591-119	Heli-Access-Step ™, Long Step – Low Skid
					X	D350-591-133	Heli-Access-Step ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	Heli-Access-Step ™, Short Step – High Skid, LH
	X			D350-591-122	Heli-Access-Step ™, Short Step – High Skid, RH
		X		D350-591-123	Heli-Access-Step ™, Short Step – Low Skid, LH

58785

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3

REF TCCA STC: SH92-6

REF FAA STC: SH967NE

PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 Heli-Access-Step™ (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

CHANGE:

FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:

QTY -111A	QTY -113	QTY -115	QTY -117A	QTY -119	Part Number	Description
X					D350-591-111A	Heli-Access-Step™, Long Step – High Skid
	X				D350-591-113	Heli-Access-Step™, Short Step – High Skid
		X			D350-591-115	Heli-Access-Step™, Short Step – Low Skid
			X		D350-591-117A	Heli-Access-Step™, Pre-Flight Step
				X	D350-591-119	Heli-Access-Step™, Long Step – Low Skid
	1				D2310	STEP ASSEMBLY (HIGH-SHORT)
1					D2311	STEP ASSEMBLY (HIGH-LONG)
		1			D2354	STEP ASSEMBLY (LOW-SHORT)
				1	D2355	STEP ASSEMBLY (LOW-LONG)
4	2	2	2	2	D2171 ✓	CLAMP
4	2	2	2	2	D2182B035 ✓	CUSHION
8	4	4	4	4	D2274 ✓	RADIUS BLOCK
			1		D2362-041 ✓	SUPPORT BRACKET
2	1			1	D2362-3 ✓	SUPPORT BRACKET
		1			D2362-5	SUPPORT BRACKET
2	1	1	1	1	D3595-200-300	CUSHION (NEW)
2	2	2		2	AN3-37A	BOLT
		4			AN4-20A	BOLT (REPLACED, WAS AN4-16A)
8	4			4	AN4-21A	BOLT (REPLACED, WAS AN4-20A)
1	1	1	4	1	AN4-22A ✓	BOLT
4	4	4	4	4	NAS1149D0363J	WASHER (OR AN960JD10)
10	6	2	4	6	NAS1149D0463J ✓	WASHER (OR AN960JD416)
		4			NAS1149D0416J	WASHER (OR AN960JD416L)
2	2	2		2	MS21042L3	NUT
9	5	5	4	5	MS21042L4 ✓	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE #02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE.	JPH	10.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STEP CUSHION CHANGE	NTS
DATE	10.06.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

THE DSI-9525-XXX-KITS THAT ARE AVAILABLE FROM DART TO UPGRADE THE D350-591-111A/-113/-115 KITS @ CHG 004 (OR EARLIER), THE D350-591-117A KIT @ CHG 002 (OR EARLIER) AND THE D350-591-119 KIT @ CHG 003 (OR EARLIER) ARE AS FOLLOWS:

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				DSI-9525-011	STEP CUSHION KIT (FOR D350-591-111A)
	X			DSI-9525-013	STEP CUSHION KIT (FOR D350-591-113/-119)
		X		DSI-9525-015	STEP CUSHION KIT (FOR D350-591-115)
			X	DSI-9525-017	STEP CUSHION KIT (FOR D350-591-117A)
2	1	1	1	D3595-200-300	CUSHION
		4		AN4-20A	BOLT
8	4			AN4-21A	BOLT
			4	AN4-22A	BOLT
8	4	4	4	NAS1149D0463J	WASHER (OR AN960JD416)
8	4	4	4	MS21042L4	NUT

INSTRUCTIONS:

TO INSTALL THE D3595-200-300 CUSHION:

1. REMOVE THE STEP PER ICA-D350-591 SECTION 32.2
2. REMOVE THE D2856-400-720 ABRASION STRIP PER ICA-D350-591 SECTION 32.4
3. POSITION THE D3595-200-300 CUSHION AS INDICATED ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.
4. REINSTALL THE STEP PER ICA-D350-591 SECTION 32.1 AS APPLICABLE USING THE NEW HARDWARE PROVIDED AS SHOWN ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.

WEIGHT AND BALANCE:

THERE IS A NEGLIGIBLE WEIGHT INCREASE WITH THIS MODIFICATION.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)
DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN	<i>90</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9525	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STEP CUSHION CHANGE	NTS
DATE	10.06.08	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries